

Ship April 23

Work Order ID 82227

\*82227\*

Page 1

March-27-12 7:44:08 AM

Item ID: D4294-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fitting  
 Start Date: 27/03/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 20/04/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4294	C

100	BAND SAW	0.00							
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank to 7.125"								
	Batch: <u>121246</u>								
	****GRAIN ALONG 4"*****								

110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FB008								
	DWG REV: <u>C</u>								
	FOLIO REV: <u>AA</u>								

2- deburr rough edges

4 0 12/04/05

B.A 12/04/09

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*82227\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 27/03/2012    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 20/04/2012      **Req'd Qty:** 4.00      **\* / \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Tool ID**

**Tool #**

## Plan Code

Accept	Qty
1	1
2	1
3	1
4	1
5	1
6	1
7	1
8	1
9	1
10	1
11	1
12	1
13	1
14	1
15	1
16	1
17	1
18	1
19	1
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83	1
84	1
85	1
86	1
87	1
88	1
89	1
90	1
91	1
92	1
93	1
94	1
95	1
96	1
97	1
98	1
99	1
100	1

Reject  
Qty

## Reject Number

**Insp.  
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

G.A 12 | 04 | 09

QC

## Memo

0.00

## Quality Control

121

0.00

**\*121\***

Mill Conv

## Memo

0.00

### Conventional Milling Machine

DRILL & TAP FOR HELICOIL AS PER DWG

122

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*122\***

~~A~~ 12-9-11

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82227

March-27-12 7:44:08 AM

**\*82227\***

Page 3

Item ID: D4294-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fitting

Stop **\*NS2\***

Start Date: 27/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*145\***

Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE

Start Time: 11:00

Temp: 320°F

Finish Time: 11:30

4. BK D4-12.

M-L  
12/04/13

120222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*82227\***

Page 4

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 27/03/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 20/04/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

QC3- Inspect Part Finish

0.00

**\*150\***

0.00  $S_{1764/13}$

QC

## Memo

## Quality Control

0.00

**\*151\***

24 12. 4. 13

### Small Fab

## Memo

0.00

## Small Fab

INSTALL HELICOIL AS PER DWG

QC5- Inspect part completeness to step on W/O

0.00

**\*152\***

0.00 Sixteen

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**Work Order ID 82227**

March-27-12 7:44:08 AM

**\*82227\***

Page 5

Item ID: D4294-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Fitting

Stop **\*NS2\***

Start Date: 27/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: *ST 470*

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/4/12*  
*ME*  
*12-04-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-27-12 7:44:11 AM

Page 1

Work Order ID: 82227

\*82227\*

Parent Item: D4294-1

\*D4294-1\*

Parent Item Name: Fitting

Start Date: 27/03/2012

Required Date: 20/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD  
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21209F1-10

Purchased

No

Each

66.0000

4

\*MS21209F1-10\*

\*\*

24 12-4-13

HELI COIL

Location

Loc Qty

Loc Code

ST304

66

116977

66

4

M7075T73B4.000x4.00

Purchased

No

100

f

2.1965

0.6

2.526316

0

\*M7075T73B4 000x4 000\*

\*\*

2.400'

12/04/05

7075-T73 Bar 4.0 x 4.0

Location

Loc Qty

Loc Code

MAT001

1.4055

118201

1.4055

MAT005

0.791

116153

0.75

116867

0.041

121246

2.400'

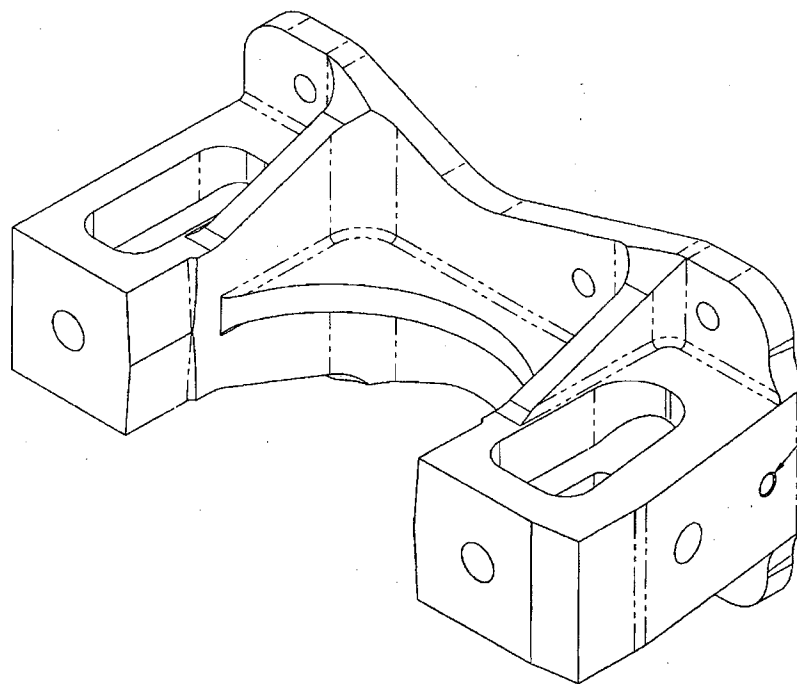
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4294-1 FITTING**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82227 MLW  
12/03/27

MS21209F1-10 HELICAL COIL, 1X  
REF

GRAIN  
DIRECTION

RELEASED  
2011-02-01

**NOTES:**

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR  
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)  
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.55 lbs

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.780 WAS 0.78 (C6-2), 1.580 WAS 1.54 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4294	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	FITTING (407 AFT)	NTS
DATE	11.01.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

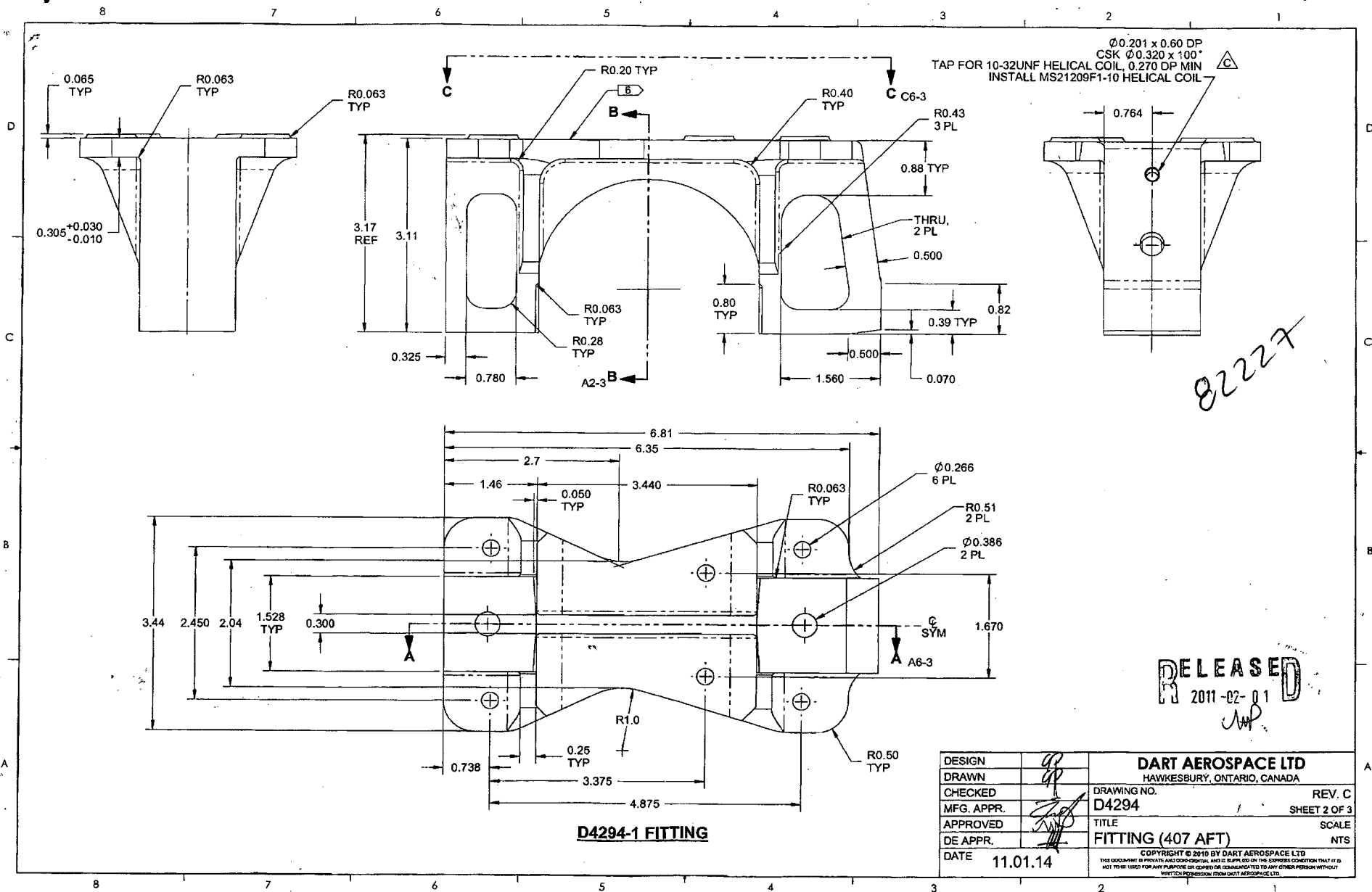
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

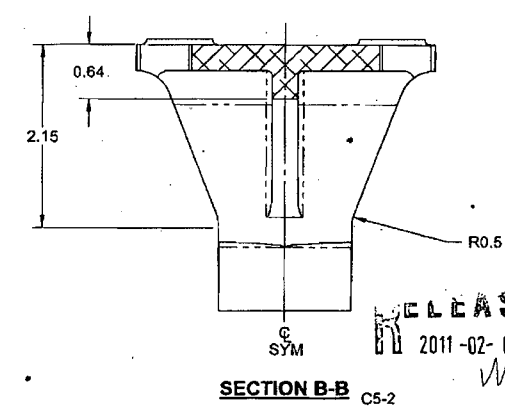
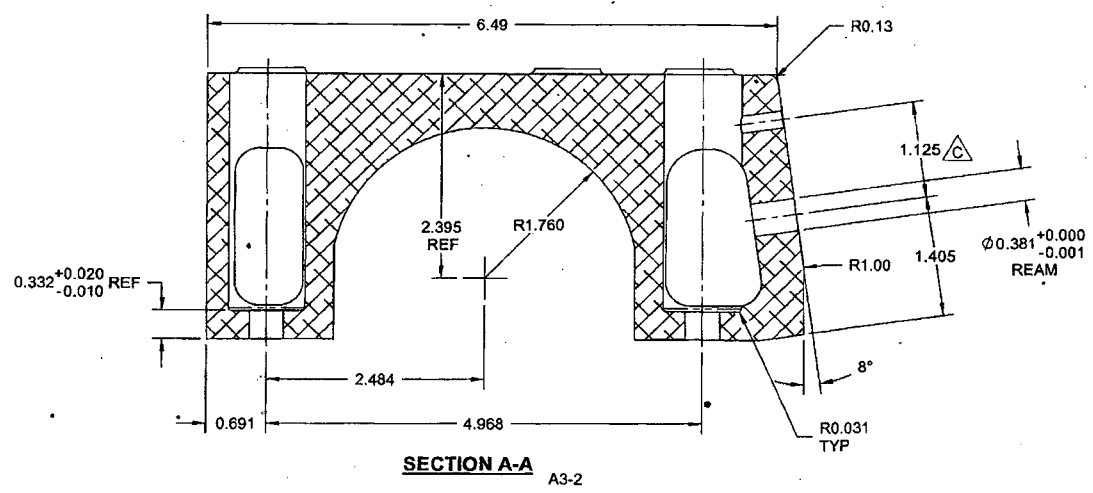
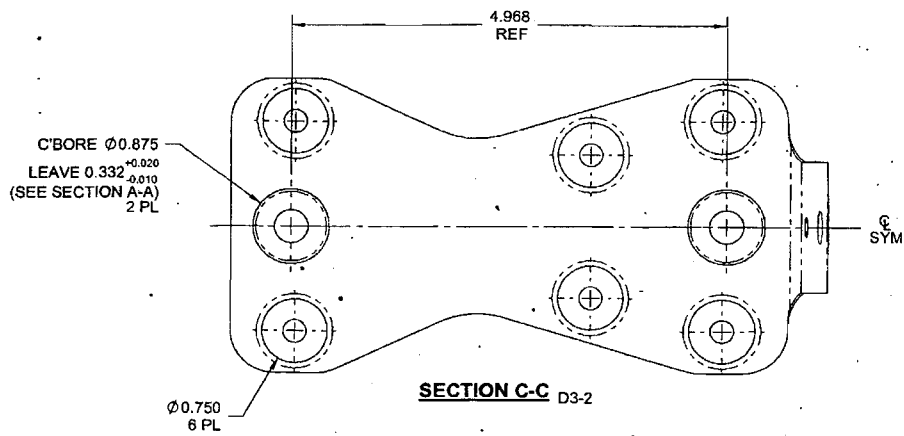
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8227



RELEASED  
2011-02-01

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4294	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (407 AFT)	NTS
DATE	11.01.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 82227
<b>Description:</b> Fitting		<b>Part Number:</b> D4294-1
<b>Inspection Dwg:</b> D4294 <b>Rev:</b> C		<b>Page 1 of 13</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	+/- .010	0.066	✓		Vern	GA-01
0.305	+ .030 / - .010	0.306	✓		"	"
R 0.063	+/- .010	R 0.063	✓		R-6	ref.
3.11	+/- .030	3.112	✓		Vern	GA-01
0.325	+/- .010	0.326	✓		"	"
0.780	+/- .010	0.780	✓		"	"
R 0.28	+/- .030	R 0.28	✓		R-6	ref.
0.80	+/- .030	0.800	✓		Vern	GA-01
1.560	+/- .010	1.560	✓		H-6	31006
0.500	+/- .010	0.492	✓		Vern	GA-01
0.070	+/- .010	0.071	✓		H-6	31006
0.39	+/- .030	0.393	✓		Vern	GA-01
0.82	+/- .030	0.820	✓		H-6	31006
0.500	+/- .010	0.496	✓		Vern	GA-01
0.88	+/- .030	0.879	✓		"	"
6.81	+/- .030	6.814	✓		H-6	31006
0.050	+/- .010	0.050	✓		"	"
1.46	+/- .030	1.455	✓		Vern	GA-01
3.44	+/- .030	3.441	✓		"	"
2.450	+/- .010	2.450	✓		"	"
2.04	+/- .030	2.044	✓		"	"
1.528	+/- .010	1.529	✓		"	"
0.300	+/- .010	0.300	✓		Mic	GA-03

<b>Measured by:</b> B.A	<b>Audited by:</b> SL	<b>Preliminary Approval:</b>
<b>Date:</b> 12/04/09	<b>Date:</b> 12/04/11	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 82227
<b>Description:</b> Fitting		<b>Part Number:</b> D4294-1
<b>Inspection Dwg:</b> D4294 <b>Rev:</b> C		<b>Page 1 of 3</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.738	+/- .010	0.738	✓		H-6	31006
0.25	+/- .030	0.250	✓		Mic	GA-03
3.375	+/- .010	3.375	✓		H-6	31006
4.875	+/- .010	4.875	✓		Vern	GA-01
R0.50	+/- .030	R0.500	✓		R-6	ref.
1.670	+/- .010	1.670	✓		Vern	GA-01
φ 0.386	+ .006 / - .001	φ 0.387	✓		"	"
φ 0.266	+ .006 / - .001	φ 0.267	✓		"	"
R0.063	+/- .010	R0.063	✓		R-6	ref
0.764	+/- .010	.766	—		RAZG	✓em
φ 0.201	+ .005 / - .001	.203	—		RAZG	✓em
φ 0.320 x 100°	+/- .010 x +/- 1/2°	.320 x 100	—		RAZG	✓em
φ 0.875	+ .010 / - .001	φ 0.876	✓		Vern	GA-01
0.332	+ .020 / - .010	0.337	✓		Mic	GA-03
φ 0.750	+/- .010	φ 0.750	✓		Vern	GA-01
2.484	+/- .010	2.484	✓		H-6	31006
4.968	+/- .010	4.968	✓		Vern	GA-01
R1.760	+/- .010	R1.760	✓		R-6	ref
R0.031	+/- .010	R0.032	✓		"	"
8°	+/- 1/2°	8°	✓		Angle Mtr	CNC-03
1.405	+/- .010	1.409	—		RAZG	✓em
φ 0.381	+ 0.000 / - 0.001	.380	—		RAZG	✓em
1.125	+/- .010	1.126	—		RAZG	✓em

<b>Measured by:</b> Y.A.	<b>Audited by:</b> JL	<b>Preliminary Approval:</b>
<b>Date:</b> 12/04/09	<b>Date:</b> 12/04/11	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

